

6061TG 1/2

Work Order ID 151701

Friday, October 07, 2016 2:33:10 PM

151701

Page 1

Item ID: D2651-1 Accept *N900040100* Setup Start *NS1*

Revision ID: Stop *NS2*

Item Name: Plug

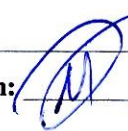
Start Date: 10/4/2016 Start Qty: 50.00 *50*

Required Date: 10/7/2016 Req'd Qty: 50.00 *50*

Cust Item ID:

Customer:

Reference:

Approvals: Process Plan:  Date: 16-10-11 Tooling: _____ Date: _____ Run Start *NR1*

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr
D2651	Rev B

100	Hardinge CNC LATHE SMALL	0.00							
100									
Hardinge	Memo	0.33							
Hardinge CNC Lathe Small	1- Turn as per Folio FA219 and Dwg D26512- Deburr								

DAS
45 16-10-28
9-89

110	QC2- Inspect parts off machine FAI/FAIB	0.00							
110									
QC	Memo	0.08							
Quality Control									

DAS
45 16-10-28
9-89

120	QC8- Inspect parts - second check	0.00							
120									
QC	Memo	0.17							
Quality Control									

DAS
45 16-10-26
9-89

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Item ID: D2651-1 Accept ***N900040100*** Setup Start ***NS1***
Revision ID: Stop ***NS2***
Item Name: Plug
Start Date: 10/4/2016 Start Qty: 50.00 ***50*** Cust Item ID:
Required Date: 10/7/2016 Req'd Qty: 50.00 ***50*** Customer:
Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
140	Chemical Conversion Coat per QSI005 4.1	0.00							
140 HandFinish Hand Finishing	Memo	0.08				(X50)	10		2016/10/26 BEB.
150	White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum	0.00							
150 Powdercoat Powder Coating	Memo (Only larger section necessary)START TIME: 3:25 OVEN TEMPERATURE: 320° FINISH TIME: 3:55	0.08				50	0	16-10-26	DAS 34 9-89
160	QC3- Inspect Part Finish	0.00							
160 QC Quality Control	Memo	0.08				(50)			DAS 38 3-89 OCT 27 2016

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Item ID: D2651-1 Accept ***N900040100*** Setup Start ***NS1***
Revision ID: Stop ***NS2***
Item Name: Plug
Start Date: 10/4/2016 Start Qty: 50.00 ***50*** Cust Item ID:
Required Date: 10/7/2016 Req'd Qty: 50.00 ***50*** Customer:
Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
170	Identify as per dwg & Stock Location: <u>FP-001</u>	0.00							
170									
Packaging	Memo	0.08							
Packaging	LOCATION : FP001								
180	QC21 - Final Inspection - Work Order Release	0.00							
180									
QC	Memo	0.83							
Quality Control									

DAS 21 9-89 x50 d ll 14/10/16

DAS 21 9-89 OCT 28 2016

DAS 21 9-89 OCT 28 2016

Picklist Print

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Page 1

Work Order ID: 151701

151701

Parent Item: D2651-1

D2651-1

Parent Item Name: Plug

Start Date: 10/4/2016

Required Date: 10/7/2016

Start Qty: 50.00

Required Qty: 50.00

Comments: IPP: A02.04.15New Issue NG
IPP: B05.12.12added deburr EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M6061T6R0.500		Purchased		No		100	f	26.8400	0.0401	2.110526			

M6061T6R0 500

6061-T6 Round Bar .500"

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
MAT012	26.84	
<u>M134776</u>	17.76	
M135377	9.08	

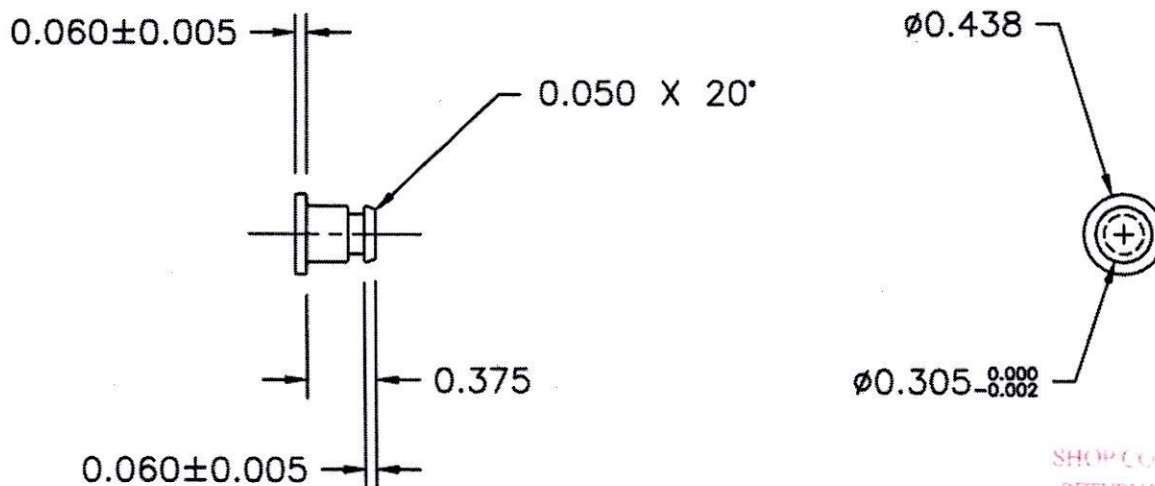
2.4 ^{PF} DAS
45 10-10-25
9-89



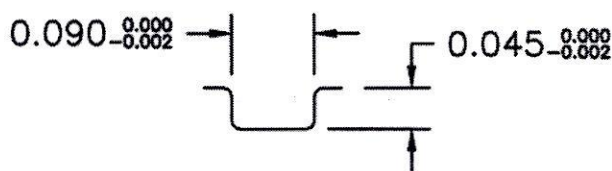
DESIGN #	DRAWN BY #	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED #	APPROVED #	DRAWING NO. D2651	REV. B SHEET 1 OF 1
DATE 03.12.19		TITLE PLUG	SCALE 1:1
A	97.03.25	NEW ISSUE	
B	03.12.19	ADD POWDER COAT, MS28775-008	

RELEASED
03.12.19 #

D2651-1 PLUG:



GROOVE DETAIL (SCALE 5:1)



SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 151701
16-10-11

D2651-1 PLUG

- 1) MATERIAL: 6061-T6 (QQ-A-225/8) OR 1100-0 (QQ-A-225/1)
- 2) FINISH: ACID ETCH & ALODINE PER DART QSI 005 4.1
POWDER COAT WHITE (4.3.5.1) PER DART QSI 005 4.3
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL SHARP EDGES 0.010 MAX

D2651-3 O-RING

- 1) MATERIAL: BUNA N, 70 DUROMETER
3/16 ID, 5/16 OD, 1/16 WIDTH
(PARKER 2-008, MS28775-008 OR EQUIVALENT)

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